

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022835**Date Inspected:** 22-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of critical weld repair of (Buttering) suspender bracket web plate is identified as X6041B for SA6029. The welder is identified as 062783. ZPMC QC is identified as Mr.Li ping. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-ESAB-Repair and B-CWR2835.

FCAW welding of critical weld repair of (Buttering) suspender bracket web plate is identified as X6550B for SA6530. The welder is identified as 062749. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-ESAB-Repair and B-CWR2835.

FCAW welding of critical weld repair of (Buttering) suspender bracket web plate is identified as X6043B for SA6037. The welder is identified as 062806. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-ESAB-Repair and B-CWR2835.

SMAW welding of weld is identified as 4G-043 of SB027-110 for SB110East. The welder is identified as 259906. ZPMC QC is identified as Mr.Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2214-Tc-U4b-1.

SMAW welding of weld is identified as 1G-018 of SB026-110 for SB110 West. The welder is identified as

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259956. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2211-Tc-U4b-1.

FCAW welding of weld is identified as 2G-101 of SB026-110 for SB110 West. The welder is identified as 058792. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-ESAB.

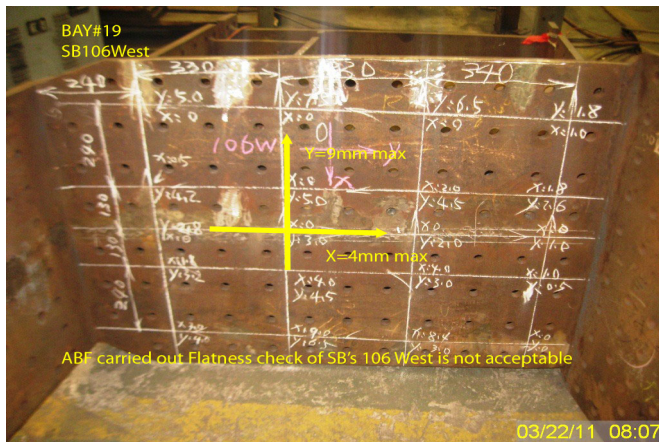
ZPMC personnel performing Heat straightening of Bike path stringer plate flange is identified as BK97A for BK024A-001 is in progress as per HSR1 (B)-10213.

ABF QC personnel carried out flatness checking of suspender bracket is identified as SB106West edge plate , measured values of distortion found $X=0\text{mm min} / 4\text{mm max}$ and $Y=0.5\text{mm min} / 9\text{mm max}$ is not appeared to comply with project specification.

ZPMC QC NDT MT personnel performing MT of bike path is identified as BK004B-001 MEP fillet welds is in progress.

ZPMC personnel performing cutting and beveling of CWR 2835 locations on cable bracket web plate is in progress.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer